

Work Order ID 134489

134489

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Vednesday, July 08, 2015 3:16:51 PM

Item ID: D119-796-251 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT Crosstube Installation with Step (no hardware)
 Start Date: 7/07/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUL 10 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-251	D								
110	Document Control	0.00							
110									
DOC	Memo	0.00							
Doc. Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D119-796-251 chg 002								
120	Pick Kit	0.00							DAS
120	Packaging								41
Packaging	Memo	0.00							9-89
Packaging									15-8-25
130	Crosstubes	0.00							DAS
130									41
Crosstubes	Memo	0.00							9-89
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-251								15-8-25
	Torque all clamps to 50 IN-LBS max.								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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140	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
140									
QC	Memo	0.00							
Quality Control	***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***								AUG 7 5 2015
150	Packaging	0.00				1			DAS 41 9-89
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-251								15-8-26
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									ML5 AUG 2 6 2015

For final assembly

ML5 AUG 2 6 2015

DQA: _____ Date: _____



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134489

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-241		Manufactured	No				Each	0.0000		1			
D119-796-241					131318				**	1	DAS 41 9-89	15-8-25	
AFT Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	52.0000		4			
D5123-3									**		DAS 41 9-89	15-8-25	
Clamp Cushion													

Location	Loc Qty	Loc Code
LG055	13	
133460	13	
lg55	39	
126747	12	
127133	6	
131871	21	

D5149-043		Manufactured	No				Each	2.0000		2			
D5149-043					134432				**		DAS 41 9-89	15-8-25	
Aft Step Base Assembly										2			

Location	Loc Qty	Loc Code
LG054	1	
131333	1	
LG058	1	
129892	1	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

Each

176.0000

4

MS21920-25

Clamp

DAS
41
9.89

15-8-25

Location

Loc Qty

Loc Code

FG

10

120920

10

LG050

26

M130400

10

M131367

3

M132169

11

M132522

2

LG057

140

M132674

40

M132675

100

4

DQA: _____ Date: _____



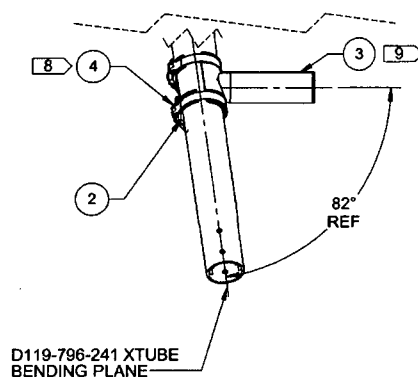
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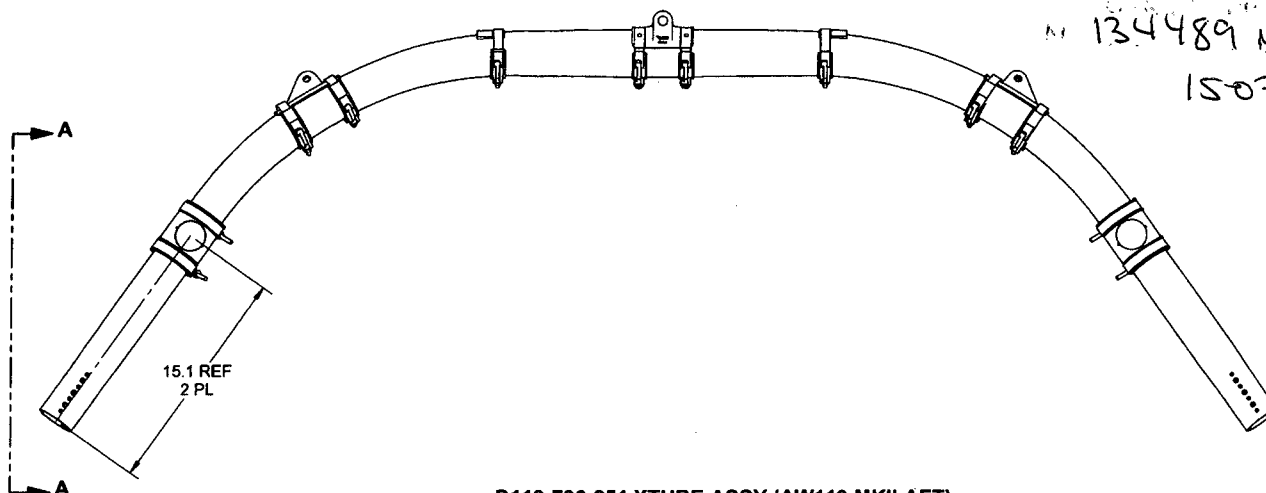
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ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO. REV. D	
MFG. APPR.	DD	D119-796-251 SHEET 1 OF 1	
APPROVED	HS	TITLE SCALE	
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT) NTS	
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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